

84011

Page 1

Accept

N900040100

Setup Start *NS1*

Stop *NS2*

Start Date: 01/05/2012 **Start Qty:** 2.00

2

Cust Item ID:

Required Date: 15/05/2012 **Req'd Qty:** 2.00

2

Customer:

Reference:

Run Start *NR1*

Approvals: Process Plan: MLJ

Date: 12/05/01

Tooling:

Date:

Stop *NR2*

QC:

Date:

SPC (Y/N):

Date:

Draw Nbr	Revision Nbr
D4092	B

0.00

100

Packaging	Memo
-----------	------

0.00

Packaging

0.00

110

Small Fab Memo

0.00

Small Fab

Assemble as per Dwg
Torque screws up to 15-25 in- lbs

QC5- Inspect part completeness to step on W/O

0.00

120

QC Memo

0.00

Quality Control

2x _____ *ES* 12/05/30

2x _____ *ES* 12/05/30

72
R34 _____

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 84011

May-01-12 10:41:12 AM

84011

Page 2

Item ID: D4092-042

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Maintenance Step Assembly

Start Date: 01/05/2012 Start Qty: 2.00

2

Cust Item ID:

Required Date: 15/05/2012 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

130 Identify as per dwg & Stock Location: **8270** 0.00***130***

Packaging

Memo

0.00

Packaging

2x. _____ **SP**
12-5-30

140 QC21- Final Inspection - Work Order Release 0.00

140

QC

Memo

0.00

Quality Control

12/5/30 **MF**
12-05-30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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NOTE: Date & initial all entries

Picklist Print

May-01-12 10:41:15 AM

Page 1

Work Order ID: 84011

84011

Parent Item: D4092-042

D4092-042

Parent Item Name: Maintenance Step Assembly

Start Date: 01/05/2012

Required Date: 15/05/2012

Start Qty: 2.00

Required Qty: 2.00

Comments:

IPP REV:A NEW ISSUE 10-10-08 JLM VERIFIED:DD

IPP

REV:B AS PER ECN 11-639 JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4092-1 *D4092-1* Maintenance Step		Manufactured	No				Each	6.0000	**	4		12/05/30	
				<u>Location</u>			<u>Loc Qty</u>	<u>Loc Code</u>					
				GA			5						
				77852			1						
				80564			2						
				81734			2						
				ST241A			1						
				74303			1						
D4093-1 *D4093-1* Bracket		Manufactured	No				Each	1.0000	**	2		12/05/30	
				<u>Location</u>			<u>Loc Qty</u>	<u>Loc Code</u>					
				ST195			1						
				82766			1						
D4093-3 *D4093-3* Bracket		Manufactured	No				Each	15.0000	**	2		12/05/30	
				<u>Location</u>			<u>Loc Qty</u>	<u>Loc Code</u>					
				ST139E			6						
				83639			6						
				ST195			9						
				77850			1						
				80084			1						
				82767			7						

B83850 (2x)

B83639 (2x)

W/O:		WORK ORDER CHANGES					
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Picklist Print

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Page 2

Work Order ID: 84011

Parent Item: D4092-042

Parent Item Name: Maintenance Step Assembly

84011

D4092-042

Start Date: 01/05/2012

Required Date: 15/05/2012

Start Qty: 2.00

Required Qty: 2.00

D4093-5 Manufactured No

Each 2.0000

4

D4093-5

Bracket

**

Location

Loc Qty

Loc Code

ST124

2

80085

2

MS24694-S54

Purchased No

Each 116.0000

4

MS24694-S54

Screw

**

Location

Loc Qty

Loc Code

ST289A

116

120142

4

120361

2

121166

60

121524

50

MS24694-S55

Purchased No

Each 90.0000

16

MS24694-S55

Screw

**

Location

Loc Qty

Loc Code

ST289A

90

119307

33

120910

55

121444

2

MS24694-S56

Purchased No

Each 104.0000

4

MS24694-S56

SCREW

**

Location

Loc Qty

Loc Code

ST289A

104

120142

12

121340

92

May-01-12 10:41:15 AM

Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Picklist Print

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Page 3

Work Order ID: 84011

Parent Item: D4092-042

Parent Item Name: Maintenance Step Assembly

84011

D4092-042

Start Date: 01/05/2012

Required Date: 15/05/2012

Start Qty: 2.00

Required Qty: 2.00

NAS1149D0332J

Purchased

No

Each

2,420.000

24

NAS1149D0332.J

**

Washer

Location

Loc Qty

Loc Code

ST298

2420

105793

12

110985

4

117087

89

119042

38

119717

541

120644

193

121011

1543

24

MS21042L3

Purchased

No

Each

3,140.000

24

MS21042L3

**

Nut

Location

Loc Qty

Loc Code

ST300

3140

117441

16

117885

32

118451

5

118927

3

119017

1131

119075

138

121349

815

121444

1000

24

May-01-12 10:41:16 AM

Shop Packet Print

Page 3

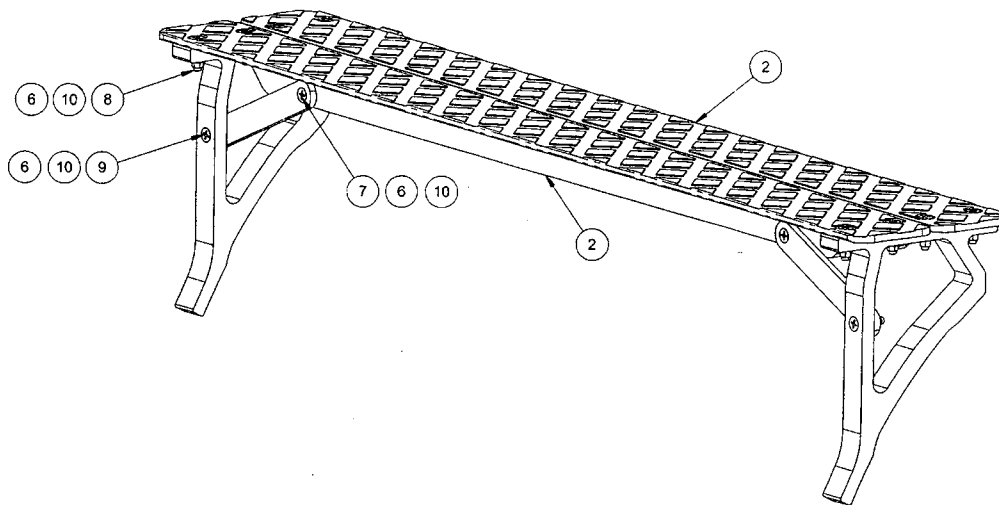
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D4092-041 MAINTENANCE STEP ASSEMBLY

ITEM	QTY -041	PART NUMBER	DESCRIPTION
1	X	D4092-041	MAINTENANCE STEP ASSEMBLY
2	2	D4092-1	MAINTENANCE STEP
3	1	D4093-1	BRACKET
4	1	D4093-3	BRACKET
5	2	D4093-5	BRACE
6	12	MS21042L3	NUT
7	2	MS24694-S54	SCREW
8	8	MS24694-S55	SCREW
9	2	MS24694-S56	SCREW
10	12	NAS1149D0332J	WASHER

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NO. 84011 MCT
12/05/01

RELEASED
2011-09-22
JW

B	REDRAWN, LOWERED FOR AESTHETICS	RF	11.07.27
A	NEW ISSUE	RF	10.09.16
REV.	DESCRIPTION	BY	DATE
DESIGN	RF		
DRAWN	RF		
CHECKED	RF		
MFG. APPR.	RF		
APPROVED	RF		
DE APPR.	RF		
DATE	11.07.27		

DART AEROSPACE USA, INC.
KENT, WA

DRAWING NO. **D4092** REV. B
SHEET 1 OF 6
TITLE **MAINTENANCE STEP ASS'Y** SCALE NTS

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

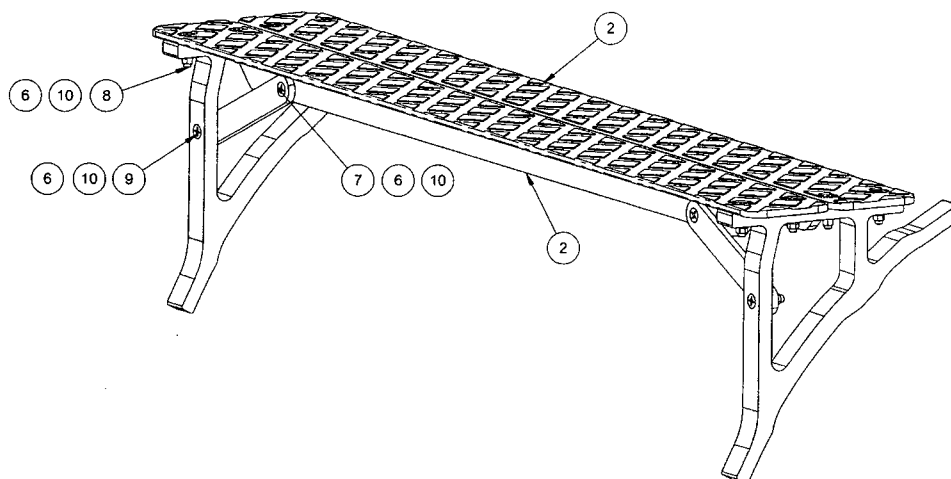
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

ITEM	QTY	P/N	DESCRIPTION
1	X	D4092-042	MAINTENANCE STEP ASSEMBLY
2	2	D4092-1	MAINTENANCE STEP
3	1	D4093-1	BRACKET
4	1	D4093-3	BRACKET
5	2	D4093-5	BRACKET
6	12	MS21042L3	NUT
7	2	MS24694-S54	SCREW
8	8	MS24694-S55	SCREW
9	2	MS24694-S56	SCREW
10	12	NAS1149D0332J	WASHER



D4092-042 MAINTENANCE STEP ASSEMBLY



RELEASED
2011-09-22
JW

DESIGN	RF	DART AEROSPACE USA, INC. KENT, WA	
DRAWN	RF		
CHECKED	<i>RF</i>	DRAWING NO. D4092	REV. B
MFG. APPR.	<i>RF</i>	SHEET 2 OF 6	
APPROVED	<i>RF</i>	TITLE	SCALE
DE APPR.	<i>RF</i>	MAINTENANCE STEP ASS'Y	NTS
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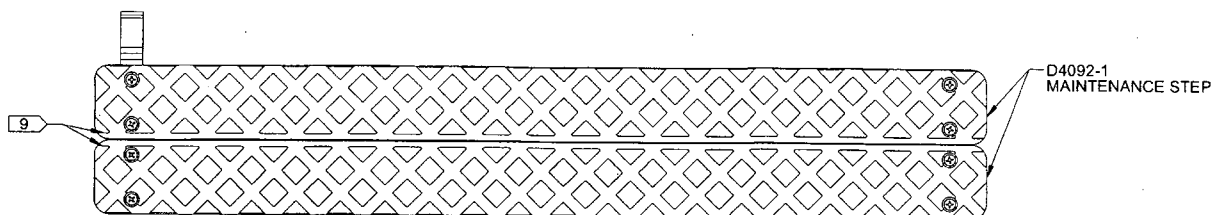
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

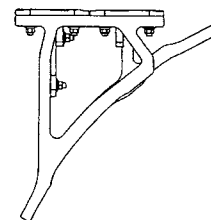
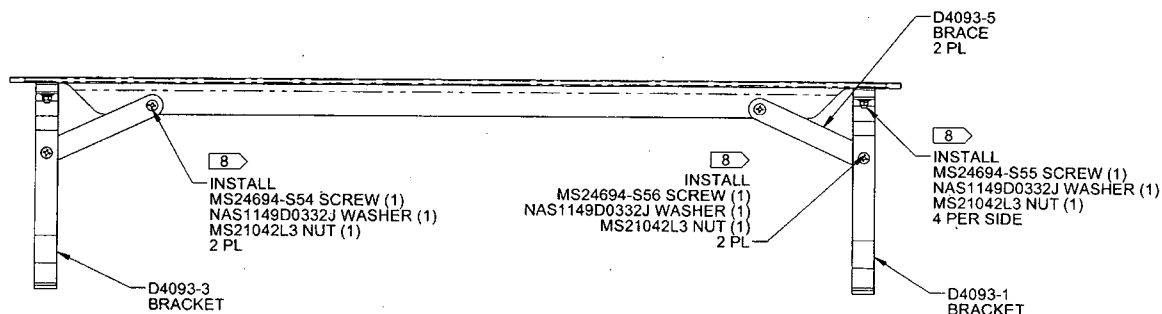
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



84011



D4092-041 MAINTENANCE STEP ASSEMBLY

RELEASED
2011-09-22

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: PER QSI 044 6.1
- 7) WEIGHT: 5.37 lbs
- 8) TORQUE SCREWS UP TO 15-25 in-lb (1.7-2.8 N-m)
- 9) GRIP CUTOUT TOWARD CENTER

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CHECKED	RF	DRAWING NO.	REV. B
MFG. APPR.	RF	D4092	SHEET 3 OF 6
APPROVED	RF	TITLE	SCALE
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

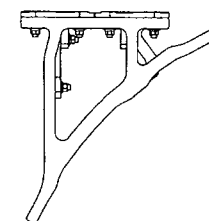
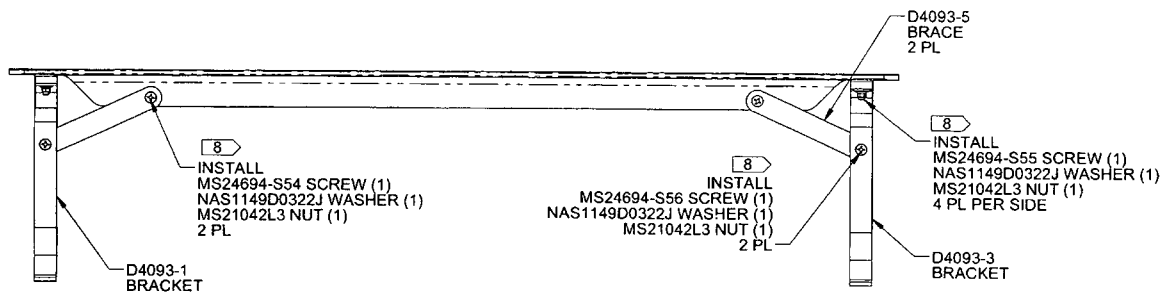
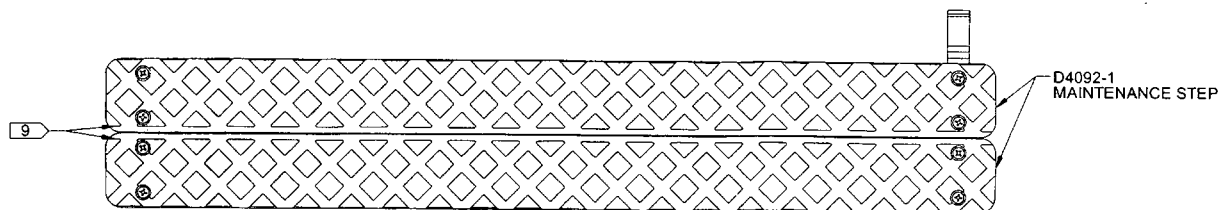
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

84011



RELEASED
2011-09-22
JW

D4092-042 MAINTENANCE STEP ASSEMBLY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: PER QSI 044 6.1
- 7) WEIGHT: 5.37 lbs
- 8) TORQUE SCREWS UP TO 15-25 in-lb (1.7-2.8 N-m)
- 9) GRIP CUTOUT TOWARD CENTER

DESIGN	RF	DART AEROSPACE USA, INC.	
DRAWN	RF	KENT, WA	
CHECKED	<i>MP</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>MP</i>	D4092	SHEET 4 OF 6
APPROVED	<i>MP</i>	TITLE	SCALE
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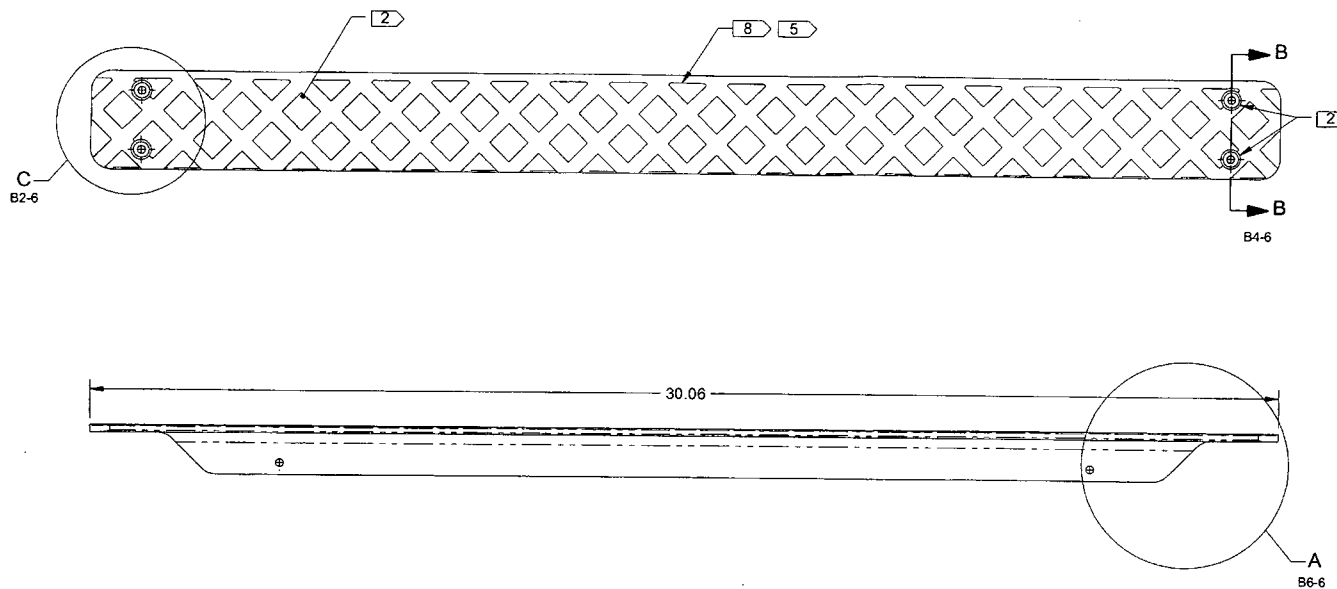
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D4092-1 MAINTENANCE STEP
(MAKE FROM D2761 EXTRUSION)

RELEASED
2011-09-22
JW

NOTES:

- 1) MATERIAL: MAKE FROM D2761 EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
BLACK ANTI-SKID PAINT GRIP AREA AS INDICATED PER DART QSI 005 4.4
MASK RECTANGULAR CUTOUT PRIOR TO APPLICATION OF ANTI-SKID
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX, NOT REQUIRED TO DEBURR GRIP AREA
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.97 lbs
- 8) MACHINE 0.69 x 0.69 GRIP 0.030 DEEP AT 45° PATTERN 0.38 APART

DESIGN	RF	DART AEROSPACE USA, INC.	
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MFG. APPR.	<i>MP</i>	D4092	SHEET 5 OF 6
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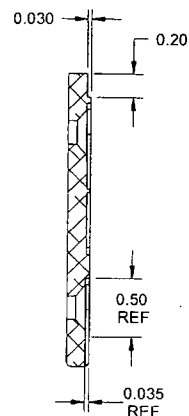
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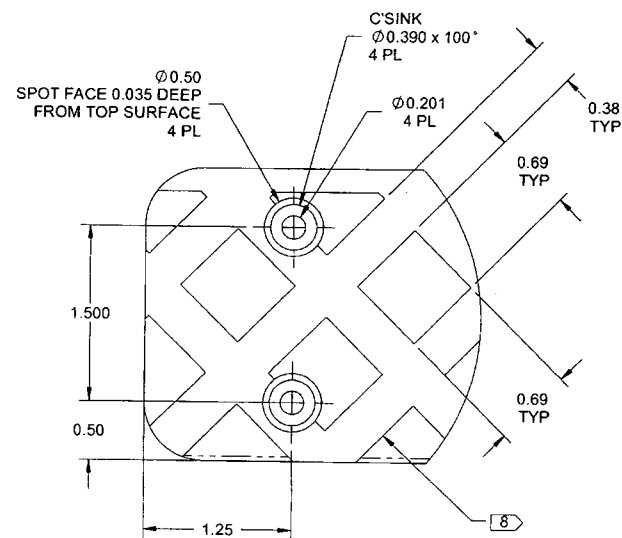
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NOTE: Date & initial all entries

DETAIL A B3-5
SCALE 3X, TYP



SECTION B-B C3-5
SCALE 3X, TYP



DETAIL C C8-5
SCALE 3X, TYP

RELEASE
2011-09-22

DESIGN	RF	DART AEROSPACE USA, INC.	
DRAWN	RF		
CHECKED	<i>RF</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>RF</i>	D4092	SHEET 6 OF 6
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